

Work Order ID 86762-2

July-06-12 2:19:19 PM

86762

DRAB GREEN

Page 1

Item ID: D3405-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 7/06/12 Start Qty: 30.00 *30*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 30.00 *30*

Customer:

Reference:

Approvals: Process Plan: Date: 7-07-12

Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3405	Rev B
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100		0.00							
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100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

30 0 Jm 12-7-12

30 0 Jm 12-7-12

5.26.12

WTS
30

Work Order ID 86762

July-06-12 2:19:19 PM

86762

Page 2

Item ID: D3405-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug Assembly

Start Date: 7/06/12

Start Qty: 30.00

30

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr

2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

0.00

0.00

19

12/07/25

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DA 12/6/26

19

150

150

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

0.00

0.00

19

12-8-14

Work Order ID 86762

86762

Page 3

July-06-12 2:19:19 PM

Item ID: D3405-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 7/06/12 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.00							
Quality Control									

170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

180	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating									

m164476

8-15
 START TIME: 8:00
 OVEN TEMPERATURE: 3200 F
 FINISH TIME: 8:45

DRAB GREEN
 MF
 12-08-17 8X6
 m1
 12/08/20

Work Order ID 86762

July-06-12 2:19:19 PM

86762

Page 4

Item ID: D3405-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 7/06/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center

Operation
Description

Set Up
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

Sx d H 12/08/20

200

Identify as per dwg & Stock Location: *523*

0.00

200

Packaging

Memo

0.00

Packaging

SP 8 12/08/20 *(82)*

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MUJ 12 108123

ME 12-08-22

Picklist Print

July-06-12 2:19:19 PM

Page 1

Work Order ID: 86762

Parent Item: D3405-041

Parent Item Name: Lug Assembly

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1 GHW Lug		Manufactured	No			100	Each	126.0000	1	30			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		126							
				83879		26							
				85100		100							
M304S11GA 304/316 0.125 Sheet		Purchased	No			150	sf	45.0260	0.154	4.863159			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		45.026							
				121380		23.9							
				121780		21.126							

85451x3

EL 12-8-14

16

5.0

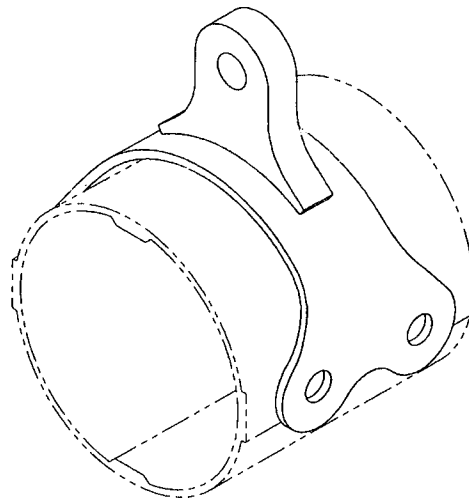
121380

Jm 12-7-1

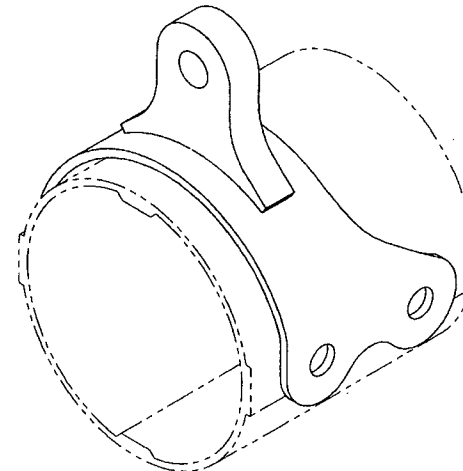
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86762 RD-079



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)







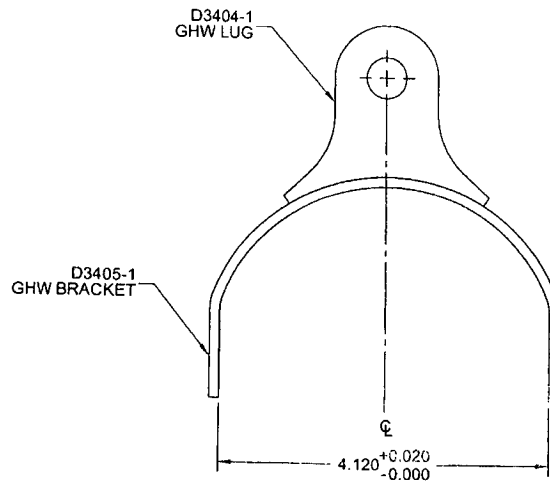
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

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08/12/18

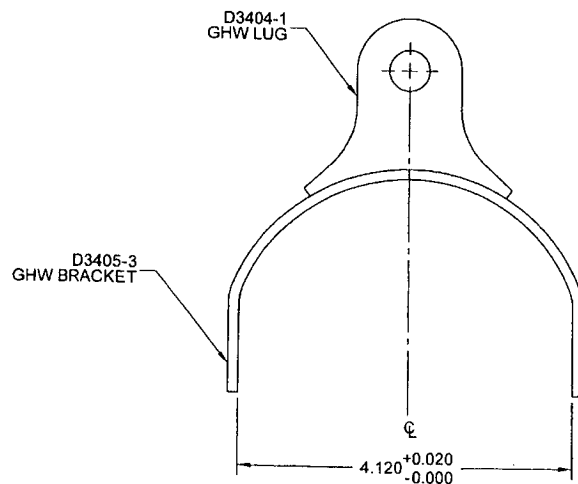
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

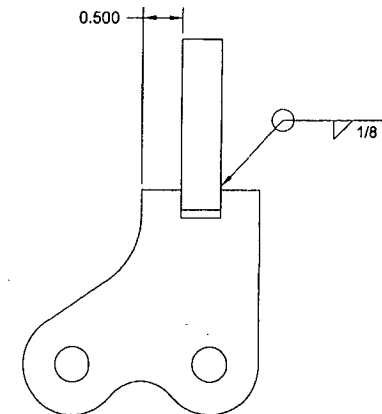
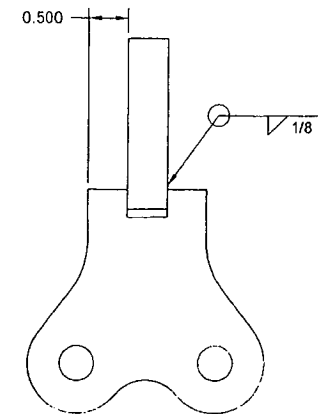
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A8 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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D3405-041 LUG ASSEMBLY



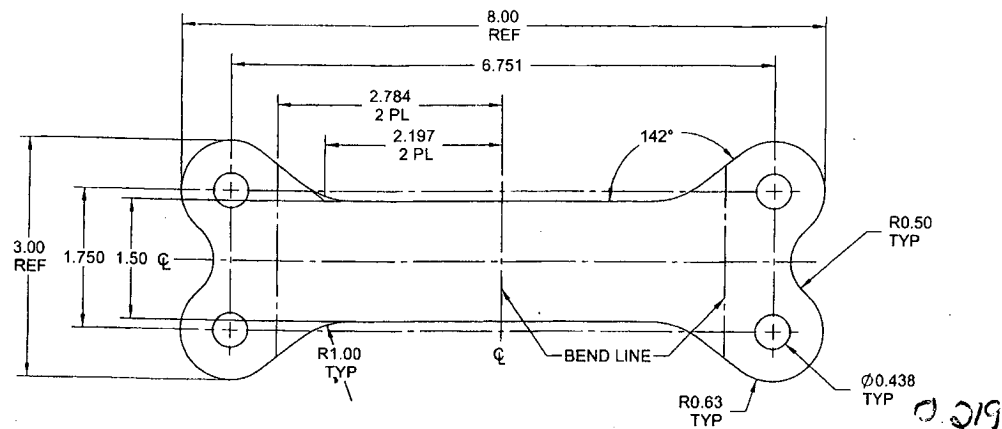
D3405-043 LUG ASSEMBLY



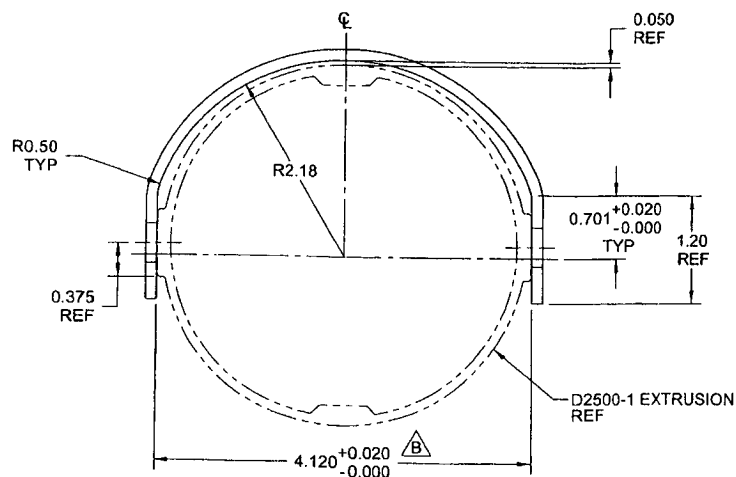
86762

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06/12/18 MJP

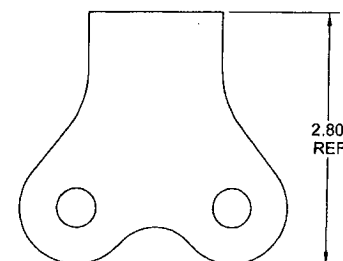
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



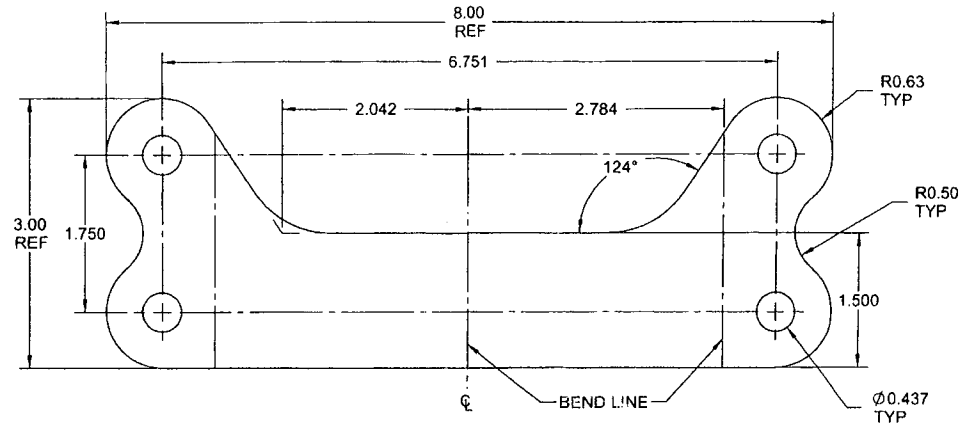
SIDE VIEW FOR REF ONLY

NOTES:

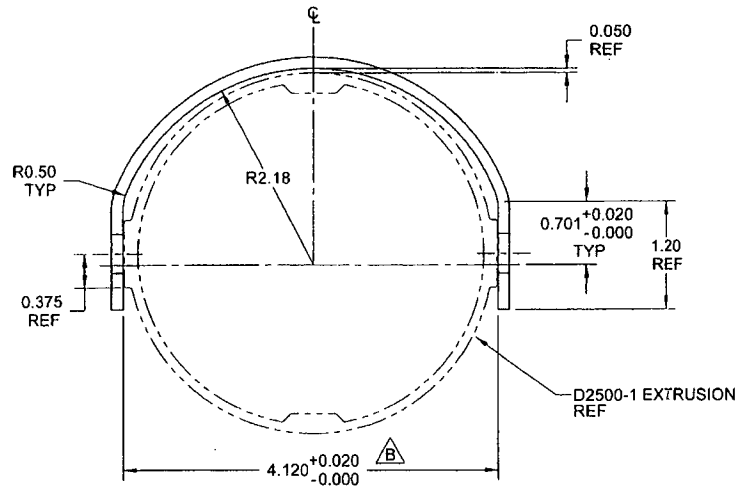
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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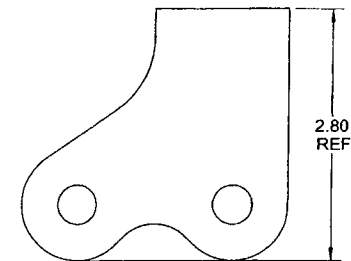
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08/09/19



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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